



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103316-101-107
Job Sheet 191730



Part No: RB T103316-101-107

Job Qty: 6 pcs

Part Name: Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG T103316 Rev B IPP Rev A 18.03.05 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	NV5000 - 1	6 pcs	5/3/19	5/3/19	0.00	1.50	NV5000 - 1		J.C.V.
							NV5000 - 2		
120	QC 2	6 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.V. 19-02-29
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S194920



Part: RB T103316-101-107

Job No: 191730

Serial No/Batch: S194920

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/29/19

Plex 3/7/19 8:12 AM Dart.lajeunesse.marie

130	QC 8	6 pcs	5/3/19	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	2mm L 14/06/30
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140	Packaging 3-1 - Stock - B4B	6 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	CL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

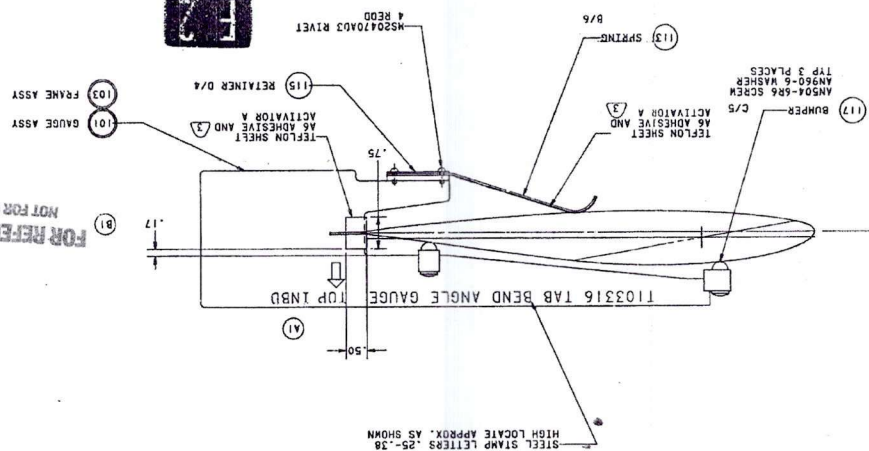
3/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	6 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 110 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio 15 Descriptions: <u>AA</u> DWG REV: <u>B</u> 2-Debur 120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 130 - QC8 Machining-4 (QC8- Inspect parts - second check) 140 - Packaging3-1 (Identify as per dwg & Stock Location: _____) 150 - QC21 (QC21- Final Inspection - Work Order Release)					JUL 15 2019 DAS 70 9-89
Part Op 110 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio 15 Descriptions: <u>AA</u> DWG REV: <u>B</u> 2-Debur 120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 130 - QC8 Machining-4 (QC8- Inspect parts - second check) 140 - Packaging3-1 (Identify as per dwg & Stock Location: _____) 150 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.750X02.000	6061-T6 Bar .750 X 2.00	.3750 ft (.0625 ea)	110-NV5000 - 1	FMI38152.80	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-NV5000 - 1	M6061T6B0.750X02.000	0	34	0	
Part Specifications					
Specifications could not be found.					

Plex 3/7/19 8:12 AM Dart.lajeunesse.marie

140307



1) WELD PER MIL-W-8604.
2) WELD PER MIL-W-6611
3) BOND PER OPS 4403. PRIOR TO BONDING WET ABRASIVE
BLAST THE SIDE OF THE TEFLON SHEET TO BE BONDED

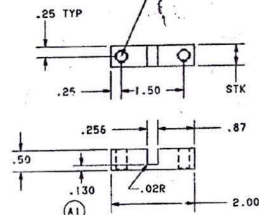
[illegible][illegible]

FOR REFERENCE
NOT FOR PRODUCTION

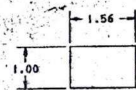
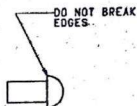
ОМС ИО²²

DWG NO. T103316

.262 DIA HOLE
CSK 100° X .31 DIA FAR SIDE
TYP 2 PLACES

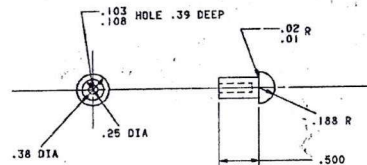


DETAIL -107 ADAPTER B/5



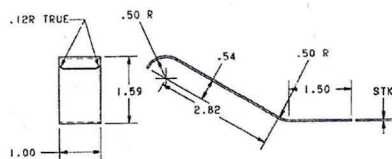
DETAIL -115 RETAINER A/2

-111 PAD B/6

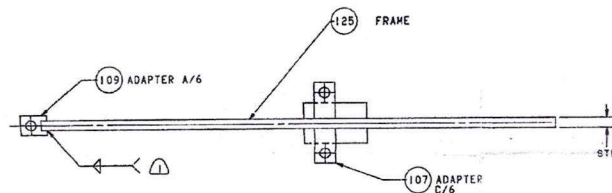


DETAIL -117 BUMPER A/3

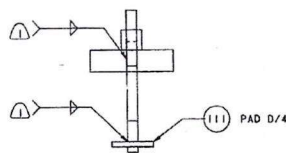
SCALE 2/1



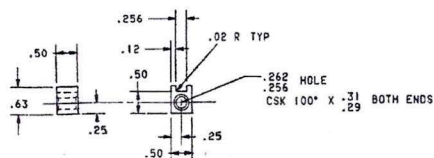
DETAIL -113 SPRING A/2



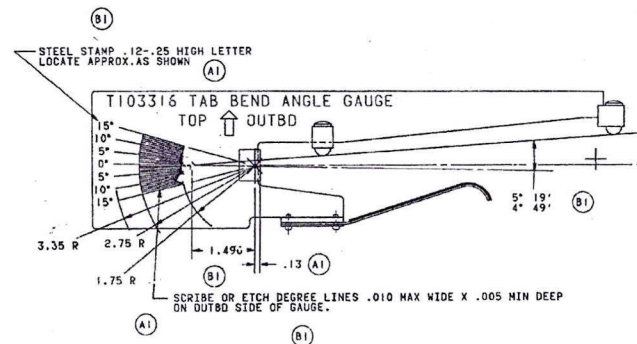
DETAIL -103 FRAME ASSY



DETAIL -109 ADAPTER C/5



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FILE COPY

DWG NO. T103316 SHEET B E

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[illegible]

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NOT FOR PRODUCTION

Steel Inspection SECTION		CON. DATE	ENGINEERING ORDER	SHEET NUMBER	LETTER	ISSUE
AUTHORITY FOR CHANGE		97489	406 B235	406 B235	T103316	1 OF 2
FOR REFERENCE TO SEE		37484/238	CHANGE	EFFECT OF 170 INSTEAD OF 170	170	1 OF 2
REASON FOR CHANGE		170	170	170	170	1 OF 2
LOCATION OF LINE ON GAUGE IS NOT PART OF THE -101 GAUGE ASSY, -105 IS NOT NEEDED.						
ITEM NO. 453956						
THICKNESS SHAPE		WIDTH WALL	LENGTH	THICKNESS	THICKNESS	THICKNESS
IN F/D, ZONES C/3 & D/3, REMOVED -105, -119, -121, & -123.						
IN F/D, ZONE B/3, REMOVED VIEW A.						
IN F/D, ZONE B/3, ADDED 4°49'-5°19'.						
IN F/D, ZONE B/4, ADDED 1.490 DIM.						
IN F/D, ZONE B/4, CHANGED STEEL STAMP SIZE FROM .25 TO .12-.25.						
IN F/D, ZONE D/1, DELETED NOTE [A].						
IN F/D, ZONE B/2, DELETED [A].						
IN F/D, ZONE B/1, ADDED .17 DIM.						
PART NUMBER		STRESS	WEIGHT	NO. OF PARTS	NO. OF PARTS	NO. OF PARTS
1		1	1	1	1	1
2		1	1	1	1	1
3		1	1	1	1	1
4		1	1	1	1	1
5		1	1	1	1	1
6		1	1	1	1	1
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211		1				

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RB T103316-101</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval March 06, 2018																	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
- Use McMaster Carr 6305A12 Teflon Tape in place of Teflon sheet and adhesive - Machine engrave all lines and text 0.010" deep - Red Anodize -103 Frame Assembly - Manufacture -117 Bumper from Nylon - Do not prime or paint assembly		- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.																			

Root Cause		FAULT CATEGORY			
Environment ☐	Design ☒	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☒
Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					